

Date: Monday, 6/19/2006 11:26:00 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
 Job Number : 27617
 Estimate Number : 11041
 P.O. Number : N/A Part Number : D2809
 This Issue : 6/19/2006 S.O. No. : N/A Drawing Number : D2809 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1
 Previous Run : 27306 Material : N/A
 Due Date : 7/5/2006 Qty: 41 Um: 20 Each
 Written By : *[Signature]* Comment: Below
 Checked & Approved By : *[Signature]* 06.06.14
 Comment : Est C 02/03/07 Now turned in house NG

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M6061T6R0500 | 6061-T6 Round Bar .500" |
| | | |
| Comment: Qty.: 0.1045 f(s)/Unit Total : 2.0895 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø Batch: <i>56"</i> <i>M19429</i> <i>MS 06/06/25</i> <i>40</i> | | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
| | | |
| Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204 Rev <u>A</u> & DWG Rev. <u>A1</u> <i>MS 06/06/25</i> <i>40</i> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>MS 06/06/25</i> <i>40</i> | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK <i>MS 06/06/26</i> <i>40</i> | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| | | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr all sharp edges as per dwg <i>MS 06/06/25</i> <i>40</i> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | 0 | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/12

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:26:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27617

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M. 06-06-27

(40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat white per QSI 005 4.3

PL 06-07-10
~~AT~~ ~~06-07-10~~

(40) +1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57388

P. 04/7/11 (41)

(41)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 06/07/12

Job Completion



W 06-07-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

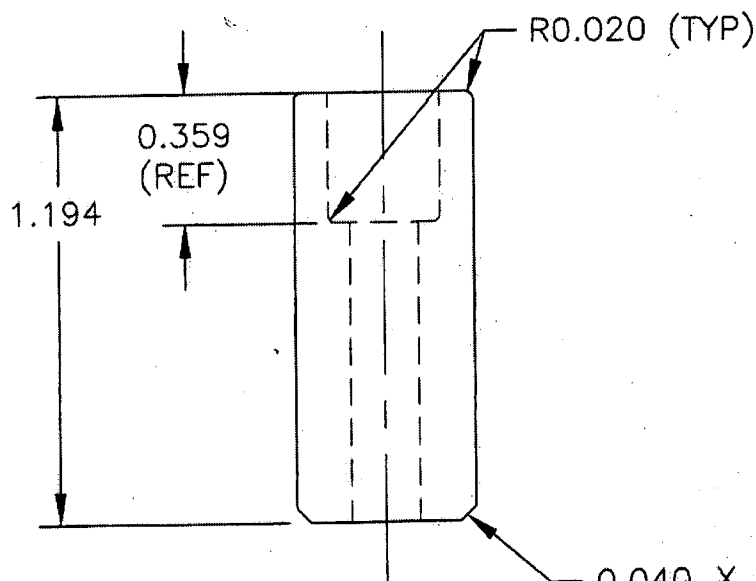
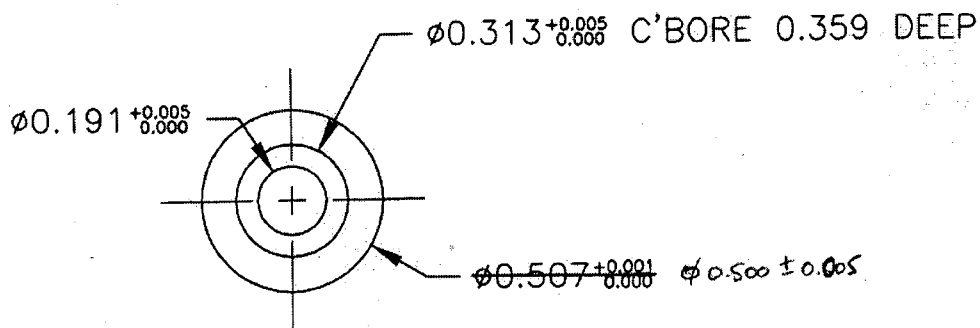
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|------------------|----------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2809 | REV. A SHEET 1 OF 1 |
| DATE 00.11.07 | | TITLE SPACER | SCALE 2:1 |
| A | 00.11.07 | NEW ISSUE | |
| A1 | 01.04.26 | ADD POWDER COAT ; $\phi 0.500$ WITH $\phi 0.507$ | |

RELEASED
00.11.13



0.040 X 45° CHAMFER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27617

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3